

Date: Thursday, 31/01/2008 8:51:34 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : PLATE

Job Number : 37124

Estimate Number : 13143

P.O. Number :

This Issue : 31/01/2008 S.O. No. :

Prsht Rev. : NC

First Issue : / / Type : SMALL /MED FAB

Previous Run :

Written By : Checked & Approved By : 

Comment : Est Rev:A 08-01-30 new issue DD verified by:

Part Number : D37311

Drawing Number : D3731 U/R

Project Number : N/A

Drawing Revision : U/R

Material :

Due Date : 07/02/2008

Qty: 10 Um: Each



Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S125 6061-T6 .125 Sheet



Comment: Qty.: 0.0504 sf(s)/Unit Total : 0.5040 sf(s)

6061T6 aluminium sheet .125" thick

(M6061T6S125)

Batch: 105646 LB 8-1-31

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3731

Dwg Rev: A LB 8-1-31

Prog Rev: A



2- Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



LB 8-1-31



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



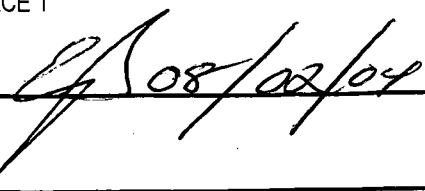
Comment: SECOND CHECK

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Deburr if necessary

 08/02/08 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 31/01/2008 8:51:34 AM
User: Linda Lacelle

Process Sheet

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Drawing Name: PLATE

Job Number: 37124

Part Number: D37311

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



**ENGINEERING
APPROVAL**



Comment: INSPECT WORK TO CURRENT STEP

060604 / 155 08.02.06

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-1 08/02/06

10X

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FeL 08/02/07 10

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FeL 08/02/07 10

10X

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1 08/02/08

10X

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: _____

-4 AS.

Supp 12/04/08 per ECN

PTO

1156

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 08.02.09

POSITIVE RECALL

EFFECTIVE

08.01.31

AUTH

41

RELEASED

DATE

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08.02.19	11	Took 1 for HAI	U	08.02.19	1	L	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

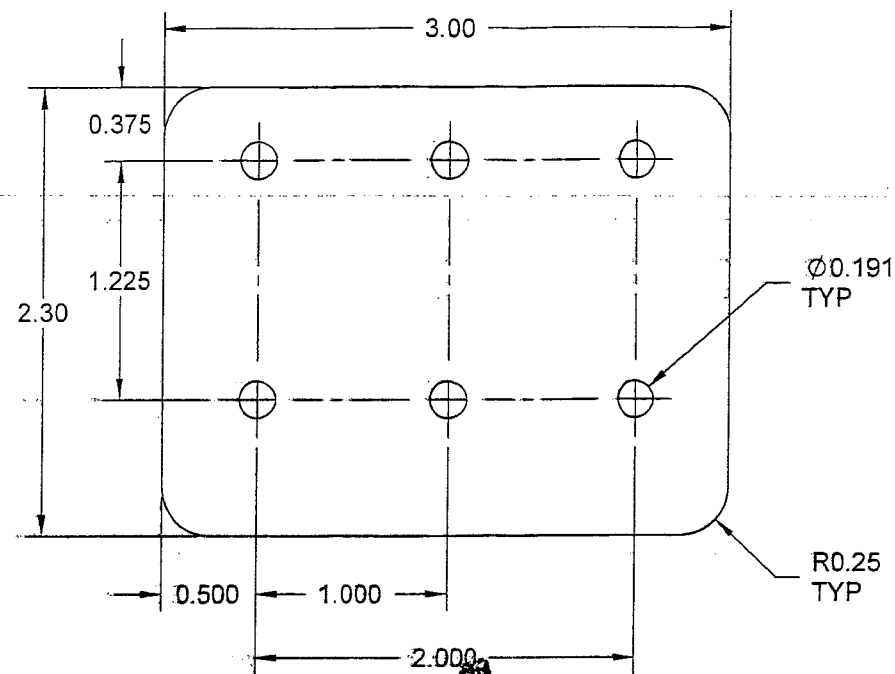
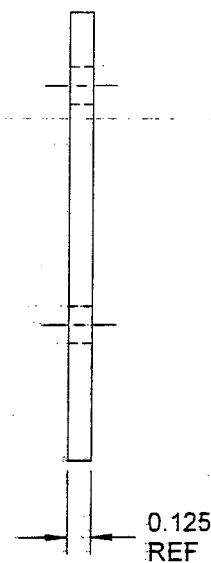
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4

3

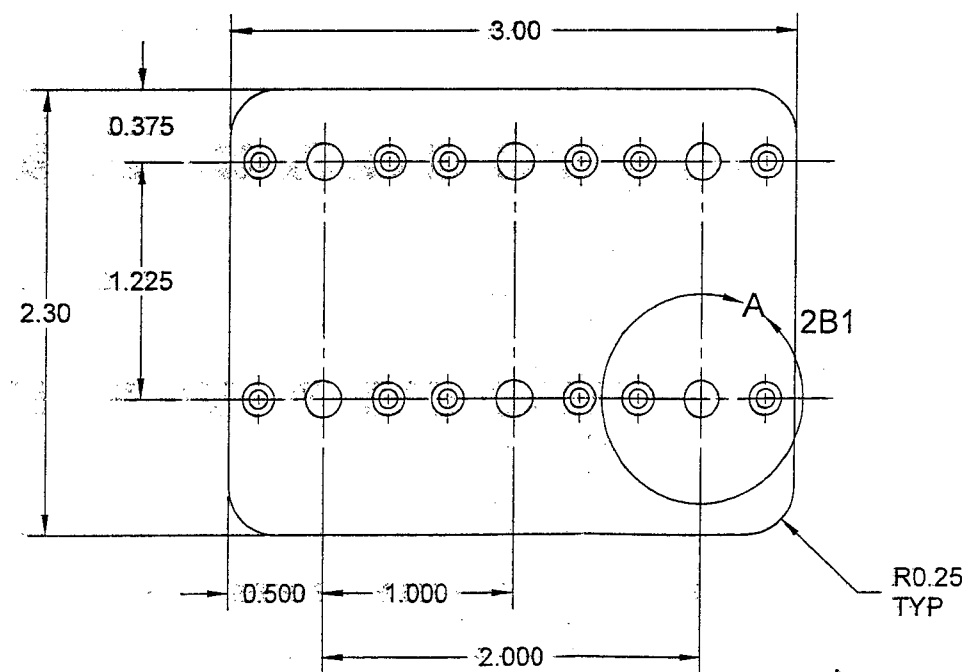
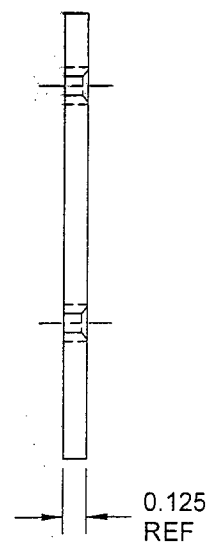
2

1



D3731-1 PLATE

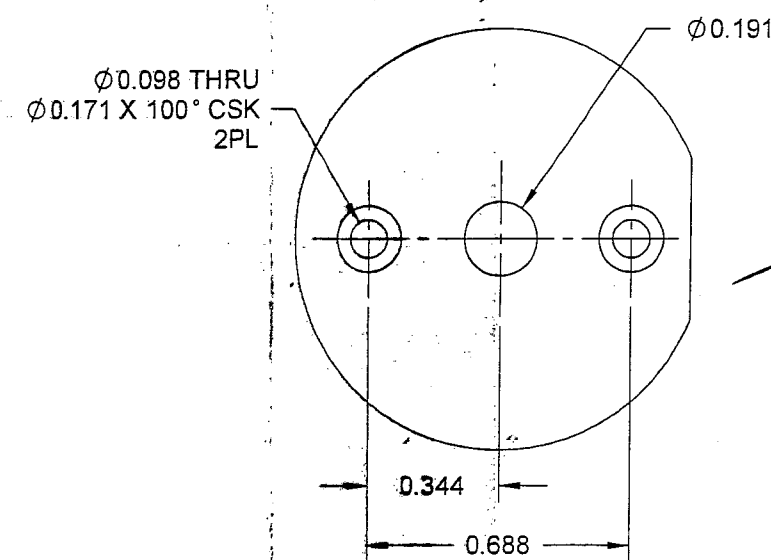
08/01/91



D3731-3 PLATE

08/01/91

PRELIMINARY ISSUE
AJS 08.01.30



DETAIL A 2B4
6 PL
SCALE 2:1

039
3200
08/01/91

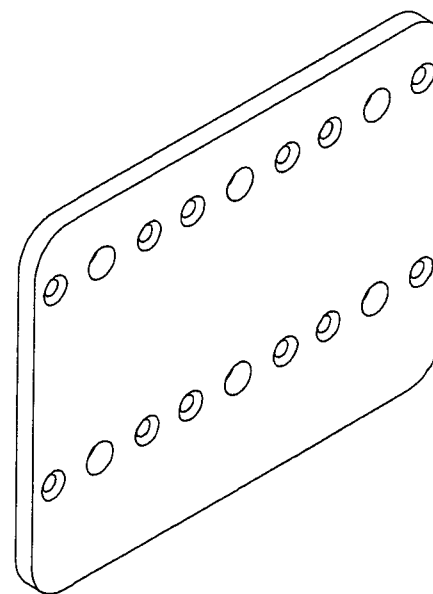
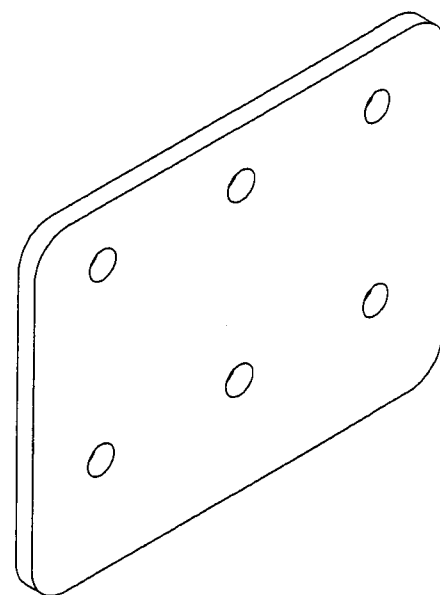
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	GEI	DRAWING NO. D3731	REV. A
MFG. APPR.			SHEET 2 OF 2
APPROVED		TITLE PLATE	SCALE 1:1
DE APPR.		COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.01.28		

8 7 6 5 4 3 2 1

D

C

B



PRELIMINARY ISSUE
ASS 08.01.28

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY D3731-1 WITH DART P/N D3731-1 USING FINE POINT PERMANENT INK MARKER
(DO NOT IDENTIFY D3731-3)
- 7) WEIGHT: 0.08 lbs

A	INITIAL RELEASE	AJS	08.01.28
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ASS		
CHECKED	UE	DRAWING NO.	REV. A
MFG. APPR.		D3731	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		PLATE	NTS
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